120 QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

M.A 11/01/12

60 d

Work Order ID 65068



Page 2

Thursday, January 06, 2011 10:37:21 AM

Item ID:

D3492-041

Accept



Setup Start



Item Name: **Start Date:**

Required Date: 1/13/2011

Revision ID:

Plug Assembly 1/6/2011

Start Qty: 60.00 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Run

Start

Stop



Date:_____ SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

130



Small Fab Small Fab

Operation Description

Small Fab

Memo

Memo

1-Deburr if neccesary □2-Tumble

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

B(1-1-25

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

HandFinish.

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

60 Bl 11-01-25.

Work Order ID 65068

Thursday, January 06, 2011 10:37:21 AM



Page 3

Item ID:

D3492-041

Accept

Setup Start



Revision ID:

Item Name:

Plug Assembly

Start Date:

Required Date: 1/13/2011

1/6/2011

Start Qty: 60.00

Req'd Qty: 60.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Date:_____

Date: Tooling:

SPC (Y/N):

Set Up/

Date:

Date:

Tool # Plan

Code

Start Run

Reject

Qty

Stop

Stop



Insp.

Reject

Sequence ID/

Work Center ID

160

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M115951.

Memo

Identify as per dwg & Stock Location: PB B 0.00

(Flat End Only) START TIME: 145
TEMPERATURE: START TIME:

0.00

0.00

Run Hours

Accept

Qty

60 BB 11-01-25

Number Stamp

170

Quality Control

QC3- Inspect Part Finish

0.00

0.00

60 d Ju 11/01/2 >

180

Packaging

Packaging

Memo

Memo

60 BR 11-01-26

0.00

Work Order ID 6506	Work	Order	ID	65068
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Thursday, January 06, 2011 10:37:21 AM



Page 4

Item ID:

D3492-041

Accept



Setup Start



Revision ID:

Item Name:

Plug Assembly

Start Date:

Required Date: 1/13/2011

1/6/2011

Start Qty: 60.00

Req'd Qty: 60.00

Operation

Description



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:_

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Start Stop

Stop



Sequence ID/

Work Center ID

190

Quality Control

Memo

Tool ID

Tool # Plan

Accept Code Qty

Reject Qty

Run

Reject Number Stamp

Insp.

Chilonay

QC21- Final Inspection - Work Order Release

0.00

0.00

Picklist Print

Thursday, January 06, 2011 10:37:56 AM

Work Order ID: 65068

Parent Item:

D3492-041

Parent Item Name: Plug Assembly



Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 60.00

Required Oty: 60.00

Comments:

IPP rev A 06.03.03 New Issue EC

IPP Rev:B 06-08-28 As per Rev B JLM

IPP Rev:C 07-12-06 Rev C dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			100	f	54.9600	0.0625	3.947368			
										No	111	1/12	2

6061-T6 Round Bar .625"

Location	Loc Oty	Loc Code	
MAT	13.6		
114415	13.6		
MAT012	41.36		
112697	10.5		
1 13796	30.86		3.94

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:		
Part No	:	PAR #:	Fault Categ	gory:	NCR: Yes	No DQ	A:	Date: _	
	Res	solution:	Disposition	1:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector
		•							
				`					
				·					

DART AEROSPACE LTD	Work Order:	45048
Description: Plug	Part Number:	D3492-1
Inspection Dwg: D3492 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototyp	е
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060				
0.060	+/-0.005	.060				
Ø0.394	+/-0.010	0.395				
Ø0.625	+/-0.010	.625				
0.090	+0.000/-0.002	-089				
0.500	+/-0.010	.500				
0.055	+0.000/-0.002	-054				
0.050 x 20°	+/-0.010	.050x28				
					:	

Measured by:		Audited by:	4 0	Prototype Approval:	N/A
Date: [()	1/12	Date:	11/01/12	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	06.06.02	New Issue P/O D3492-041	KJ/JLM
В	06.10.16	Ø0.625 was Ø0.500	KJ/JLM
С	07.11.23	Tolerances revised	KJ/EC/DD , A
D	08.06.19	0.050 x 20° dimension added	KJ/DD 💉 🔉

Dart A	eros	pace	Ltd
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W/O:			WC	RK ORDER CHANGI	ES	· · · · ·			
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·					
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	າ:	_ QA: N/C CI	osed:		Date: _	-
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	tion C	Chief Eng	QC Inspector
					ŀ				

^{*} H:\'iFORMS\Quality Assurance\approved QA\NCRWO RevE

D3492-XX PLUG (SEE TABLE)--NAS1611 PLUG (SEE TABLE)

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D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
				•	Х		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1	\vdash					ļ	D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1			`	D3492-7	PLUG
	1			1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
	L		1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COFY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 45046

DEO ATTACHED

С

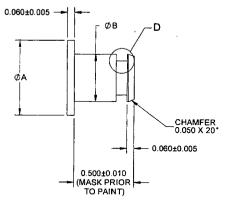
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В	ADD -04	7; UPDATE DIN	1 A FOR -045	PH	06.05.11	
Α	NEW IS	SUE		PH	06.01.04	
REV.	DESCRI	PTION		BY	DATE	
DESIG	N	pu-	DART AERO	SPACEL	TD	
DRAWN AL			HAWKESBURY, ONTARIO, CANADA			
CHECKED			DRAWING NO. RI			
MFG. APPR.			D3492		SHEET 1 OF 2	
APPROVED /			TITLE		SCALE	
DE APPR.			PLUG			
DATE	07.1	0.05	COPYRIGHT © 2007 BY THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND HOT TO BE USED FOR ANY PURPOSE OR COMED OF WATTEN PERMASSION FR	IS EUPPLIED ON THE EXPRES	S CONDITION THAT IT IS	

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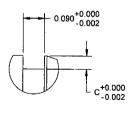
Dart Aerospace Ltd

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W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Resolution		esolution:	Disposition	1:	QA: N/C Closed: D								
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DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	n B Sign 8		Verification Approversion C Chief English						
		Section A	Chief Eng	Chief Eng	Date			Critical Eng	QO IIIspector				

-POWDER COAT THESE FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

w/o 45048

D3492-XX PLUG MACHINING DETAILS

_	P/N	Α	В	С	MATERIAL SPEC				
f.	D3492-1	0.625	0.394	0.055	M6061T6R0.625				
	D3492-3	0.750	0.582	0.045	M6061T6R0.750				
	D3492-5	0.375	0.188	0.045	M6061T6R0.375				
	D3492-7	0.500	0.270	0.045	M6061T6R0.500				
	D3492-9	0.938	0.750	0.045	M6061T6R1.000				
	D3492-11	0.850	0.664	0.045	M6061T6R0.875				
	D3492-13	0.750	0.520	0.045	M6061T6R0.750				

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M606116R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

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DEO ATTACHED

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В

DESIGN	PH	DART AERO	SPACE LTD			
DRAWN	PK	HAWKESBURY, ONTARIO, CANADA				
CHECKED	-67	DRAWING NO.	REV. C			
MFG. APPR.		D3492	SHEET 2 OF			
APPROVED /		TITLE				
DE APPR.	di	PLUG	4:1			
DATE 07.	10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EMPRISE CONDITION THAT IT IS NOT TO BE USED FOR NAME AUROSIC OR COMED OR COMMANCATED TO ANY OTHER PERSON WITHOUT WINTELL REPRESIDENT KEND AND TREPRESIDENTIAL				

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	R	lesolution:		Disposition:	QA: N/0	Closed:		Date: _					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B		Verification	Approval	A					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector					
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No: PAR #:											
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NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (NCR))					
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